Work Orde	er ID 111463 1:11:00 PM		*111	1463*						Page 1
Item ID: Revision ID:	D3488-041		Accept	*N900	<b>040</b>	100	)*	Setup Star	<sup>t</sup> *N	S1*
Item Name:	Blade Fitting LH							Sto	• <b>*</b> NI	S2*
Start Date: Required Date: Reference:	1/15/14 Start Qty: 10.00 Req'd Qty: 10.00	117		Cust Item l Customer:	ID:				IV	
Approvals:	Process Plan: MC	Date: <u>                                     </u>	Tooling: _ SPC (Y/N):		ate:			Run Star	<b>^!\!</b>	R1*
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3488 DSK101	Rev B REV D									,
*100 *100* Doosan	DOOSAN LATHE		0.00				10	Ø	ŧ	0A5 40
Doosan Lathe		oer Dwg DSK 101 & Folio i								14/02/2
110	QC2- Inspect parts off	machine FAI/FAIB	0.00							OAS
*110* QC Quality Control	Memo		0.00					<b>9</b> _		40 J (4/02/2

An.

The second

DQA:			Date:										TRAGE
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	ır.					DISPOSITION			AGAINST	DE	PARTMENT	PROCESS	
Work Orac						Rework	ı		Skid-tube Crosstube			Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fab	_	Pro	d. Eng. Coor.	Quality
	•					Use-as-is			moforming Finishing		1	e/Packaging	Other
NCR N	lo.					Suspected Unapproved			Large Fab Composite			Supplier	
Root					Desc	ription of work order update	1	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data													•
Equip/Tooling													:
Handling/Pre													
Material													
Operator		ı	1										
Offset/Setup													
Process Supplier													
Training					1								
Transport													
Unapproved													
							FA	ULT CA	TEGORY				
Landi	ng (	Gear				General		_			•		_
		Bending				Bend	<u>_</u>	Folio/I	Program	L	Oútside Dim		Pressure/Forced
	L	Centre No	ot Concer	ntric		BOM/Route	.1	Grain		_	Over/Under	<b> </b>	Set-up
		Cracks				Broken/Damage/Defect		Hardwa		L	Part Incorre	<u> </u>	Temperature/Cure
	<u> </u>	Crimp/Kir	nk/Ripple	:/Wave	L	Burrs		-1 '	tion Incomplete/Unqualified	L	Part Lost/Mi		Weld
	<u> </u>	Cuffs			<u> </u>	Contamination	$\vdash$	-	tions Incomplete/Unclear	_	Part Moved		Wrong Stock Pulled
	_	Crushing	_		$\vdash$	Countersink	$\vdash$	-{	gned/off center	$\vdash$	Positioned V	_	Joshan
		Heat Trea		T. d	-	Cut Too Short	$\vdash$	Mislab			Power Loss/	ourge	Other
	_	Inspectio		Tube	 	Drawing Drill Holos	_	Misrea					
	$\vdash$	Marks/Ch			<u> </u>	Drill Holes Finish	-	Off-set	Calibration		-		
	$\vdash$	Turning S Wave/Tw			-	Fit/Function	$\vdash$	-1	Sequence				
1	1	I AND AGE IN	visciii Tül	u <del>c</del>	ı	price unction		Journ	Jequence				

Work Order ID January-15-14 1:11:00			*111	1463*						Page 2	
Item ID: D3488- Revision ID: Item Name: Blade F	-041 itting LH		Accept	*N900	<u>040</u>	100	<b>)*</b> s	etup Star Stop	171	S1* S2*	
Start Date: 1/15/14 Required Date: 1/31/14 Reference:	<b>C</b> .,	*10* *10*		Cust Item I Customer:	D:				· IV	·7/"	
Approvals: Proces	ss Plan: Da	ate:	Tooling:	Da	ate:	_	R	un Star	<i>"\U</i>	R1*	
QC:_	Da	ate:	<b>SPC (Y/N):</b>	Da	ate:			Stop	, *N	R2*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
*120* HAAS 1	HAAS CNC VERTICAL MAC	CHINING #1	0.00				10	_Ø		M4 14/0 14/03/	93/12
HAAS CNC vertical machine	#1 1-Machine as per I	Folio FA625 & Dwg	g D34882-Deburr							/14/03/	′3
130	QC2- Inspect parts off machine	FAI/FAIB	0.00								
*120* QC Quality Control	Memo		0.00				<u>10</u>			MU 14/0	3/12
140	QC8- Inspect parts - second che	eck	0.00								
*14 <b>0</b> *	Мето		0.00				10	<b>ø</b>		TFC 2014-03-	18

Quality Control

DQA:			Date:										TOART
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:			<del></del>			·	Wo	ork Order up	date only	
Work Orde	r:					DISPOSITION		i.	AGA	AINST DE	PARTMENT/	PROCESS	,
	-				_	Rework			Skid-tube Cross	stube		Water Jet	Engineering
Part N	0.					Scrap			<b>⊢</b>	ll Fab	Prod	d. Eng. Coor.	Quality
	-					Use-as-is		i .	~ <b>—</b>	shing		e/Packaging	Other
NCR N	o					Suspected Unapproved			Large Fab Comp	osite		Supplier	
Root	T				Dasc	ription of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty	Desci	or non-conformance		ief Eng			Date	Verification	QC Inspector
Design	$\dashv$	Date	Step	Qty		or non comormance	<u> </u>	ici Liig	Description		Dute	Vermodelon	Quinopoeto.
Doc/Data	$\neg$												
Equip/Tooling	ᆿ											•	
Handling/Pre													
Material	$\exists$						ļ						
Operator													
Offset/Setup													
Process													
Supplier						,	Į						
Training							Ì						
Transport													
Unapproved							Ì						
							FAI	ULT CA	TEGORY				
Landir	_					General	_	1		_	1	_	<b>-</b>
		Bending			_	Bend		4	Program		Outside Dim		Pressure/Forced
	-	Centre No	ot Concer	ntric		BOM/Route	<u> </u>	Grain		<u> </u>	Over/Under	<del></del>	Set-up
	$\dashv$	Cracks			_	Broken/Damage/Defect	_	Hardwa			Part Incorred	<u> </u>	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave	<u> </u>	Burrs	<u> </u>	4 `	ion Incomplete/Unqualifie	<sup>d</sup>	Part Lost/Mi	ssing	Weld
	_	Cuffs			-	Contamination	<u> </u>	4	tions Incomplete/Unclear	<u> </u>	Part Moved	L_	Wrong Stock Pulled
	-	Crushing			-	Countersink	-	-1	gned/off center	$\vdash$	Positioned V		Jothan
	_	Heat Trea		T 1.		Cut Too Short	$\vdash$	Mislab		L	Power Loss/	ourge	Other
		Inspectio	-	ıupe	<u> </u>	Drawing	$\vdash$	Misrea					
		Marks/Ch			$\vdash$	Drill Holes Finish	$\vdash$	Off-set	Calibration				
]		Turning S		10	$\vdash$	Fit/Function	-	-	Calibration Sequence			*	

Work Ord January-15-14		1463		*111	463*	,	-				***	Page 3
Item ID: Revision ID: Item Name:	D3488-041 Blade Fitting	LH		Accept	*N900	<b>040</b>	100	*	Setup	Start Stop	*N.	
Start Date: Required Date: Reference:	1/15/14	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item I Customer:	ID:				-	*N.	<b>ヘン</b> *
Approvals:	Process Pla	nn:	Date:	Tooling:	Da	ate:			Run	Start	*NF	₹1*
	QC:		Date:	SPC (Y/N):	Da	ate:				Stop	*NF	₹2*
Sequence ID/ Work Center II 150 *1 CO* HandFinish Hand Finishing	D	Operation Description Chemical Conversion Co	oat per QSI005 4.1	Set Up/ Run Hours 0.00	Tool ID	Tool#		Accep Qty	Qt	y I	Reject	Insp. Stamp
160 *160* Powdercoat Powder Coating		White Gloss(Ref:4,3,5,1)  Memo START TIM	007	0.00 0.00 OVEN TEMPERATURE:			-	10	<u>\$</u> _	<i>M</i> -3	3- <b>9</b> 4.	DAS 34
170 <b>*170*</b> QC Quality Control		QC3- Inspect Part Finish  Memo		0.00			Χ-	104	<u> </u>	<u> </u>	M 14	10-3/2(

DQA:			Date:										TRACT
						WORK ORDER NON-	-CC	NFO	RMANCE / UPDA				AEROSPACE
QA Closed:			Date:							Wo	ork Order up	date only	
Work Orde	ar.					DISPOSITION			,	AGAINST DE	PARTMENT/	PROCESS	
WOIK Olde	٠					Rework			Skid-tube C	Crosstube	1	Water Jet	Engineering
Part N	in					Scrap				Small Fab	Prod	d. Eng. Coor.	Quality
	•					Use-as-is			Ŭ⊢	Finishing	1	e/Packaging	Other
NCR N	lo.					Suspected Unapproved			· H	omposite		Supplier	1
	-										• 		
Root					Desc	ription of work order update	l	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description	on	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre							١						
Material					1								
Operator							1						
Offset/Setup		-											
Process			•				•						
Supplier							ļ						
Training			ļ				İ						
Transport													
Unapproved											<u> </u>		
		_					FA	ULT CA	TEGORY				·• · · · · · · · · · · · · · · · · · ·
Landi	_	1				General		11:- //	<b>3</b>	F	Outside Dim		Pressure/Forced
	<u> </u>	Bending	-+ 6	_4		Bend BOM/Boute	$\vdash$	Grain	Program		Over/Under	<u> </u>	Set-up
		Centre No	ot Concer	ntric	-	BOM/Route Broken/Damage/Defect	-	Hardwa	250		Part Incorred	-	Temperature/Cure
	-	Cracks	ale/Dimmla	//4/2002	<u> </u>	<b>-</b>	$\vdash$	4	are tion Incomplete/Unqua	lified -	Part Lost/Mi		Weld
	-	Crimp/Kir	тк/кірріе	:/wave	$\vdash$	Burrs	$\vdash$	1 .	tions Incomplete/Uncle	<del></del>	Part Moved	331118	Wrong Stock Pulled
E	⊢	Crushing			-	Contamination Countersink	-	4	gned/off center		Positioned V	/rong	Twiong stock i dired
		Crushing Heat Trea	<b>.</b> +		<u> </u>	Cut Too Short	-	Mislab	<del>-</del>	<u> </u>	Power Loss/		Other
	$\vdash$	Inspectio		Tubo	$\vdash$	Drawing	$\vdash$	Misrea		<u> </u>	J. 0Wei 2033/		Todiloi
	<u> </u>	Marks/Ch		(une	$\vdash$	Drill Holes	_	Off-set			<u>.</u>		
	$\vdash$	Turning S				Finish	$\vdash$	4	Calibration				<del></del>
	$\vdash$	Wave/Tw	•			Fit/Function	$\vdash$	┥	Sequence				
I	1	1			1	1,		1					

Work Ord  January-15-14		1463		*111	463*							Page 4
Item ID: Revision ID: Item Name:	D3488-041 Blade Fitting	LH		Accept	*N90	ი <u>ი</u> 40	100	)*	Setup	Start Stop	ı Vı.	S1* S2*
Start Date: Required Date: Reference:	1/15/14 : 1/31/14	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Ite Custom		·				ı	
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		Date:			Run	Start Stop	"171	R1* R2*
Sequence ID/ Work Center I  180 *1 A \ * HandFinish Hand Finishing	D	Operation Description  HandFinishing  Memo Install Insert	s as per Dwg D3488	Set Up/ Run Hours 0.00	Tool I	D Tool#	Plan Code	Accep Qty	Qt		Reject Number	Insp. Stamp
190 *1QA* QC Quality Control		QC5- Inspect part compl  Memo	eteness to step on W/O	0.00				10	\$_	<u>/4-</u> 3	- 36.	
200 *200* Packaging Packaging		Identify as per dwg & Sto	ock Location: 1000	0.00				<u>x</u> )	0 h <u>H</u>	¢	H	14/03/2

DQA:			Date:										TRACT
						WORK ORDER NON-	-CC	NFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:			<u>,</u>				W	ork Order up	date only	
Work Orde	or.					DISPOSITION			AGAINST	ΓDE	PARTMENT	PROCESS	
Work Ord					_	Rework			Skid-tube Crosstube	<u>,                                    </u>	I	Water Jet	Engineering
Part I	lo.					Scrap			Machining Small Fal	_	Pro	d. Eng. Coor.	Quality
	•					Use-as-is			noforming Finishing	3	1	re/Packaging	Other
NCR I	۱o.					Suspected Unapproved			Large Fab Composite	•		Supplier	
Root					Desci	ription of work order update	Ī	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design		į											
Doc/Data	Щ												
Equip/Tooling													
Handling/Pre			·									:	
Material	Щ												
Operator	Ш												
Offset/Setup	$\vdash$								<b>3</b>				
Process	<u> </u> -												
Supplier	$\vdash$												Ĭ
Training			 										
Transport												1	
Unapproved	<u> </u>	<u> </u>	<u>.                                    </u>	<b>!</b>	<u> </u>		FΔI	ULT CA	TEGORY		L.,		
Landi	ng (	Gear				General		<u> </u>	1200111			··· · ·	· · · · · · · · · · · · · · · · · · ·
20114		Bending				Bend	Г	] Folio/f	Program		Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain	,		Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	cí .	Temperature/Cure
<b>'</b>		Crimp/Kir	nk/Ripple	/Wave		Burrs	Г	Inspect	tion Incomplete/Unqualified		Part Lost/Mi	issing	Weld
		Cuffs				Contamination		Instruc	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong	_
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	'Surge	Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d			***	
		Marks/Ch	natter			Drill Holes		Off-set				<u>.</u>	
!		Turning S	equence			Finish		Out of	Calibration		· · · · · · · · · · · · · · · · · · ·		
	1	Wave/Tw	ist in Tul	oe e		Fit/Function		Out of	Sequence				

Work Orde				*111	1463*							Page 5
Item ID: Revision ID: Item Name:	D3488-041 Blade Fitting			Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop		S1* S2*
Start Date: Required Date: Reference:	1/15/14 1/31/14	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item I Customer:	D:					"IN.	.T/"
Approvals:	Process P	lan:	Date:	Tooling: SPC (Y/N):		ate:		]	Run	Start Stop	^IVI	R1* R2*
Sequence ID/ Work Center II 210	)	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Re Qt		Reject Number	Insp. Stamp
*210* QC Quality Control		Memo		0.00				ML	<b>,</b> 5	14- M	03-2	6 1-03-26

DQA:			Date:										TRACT
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:			pt			· · · · · · · · · · · · · · · · · · ·	W	ork Order up	date only	
Work Orde	er:					DISPOSITION			AGAINST	T DE	PARTMENT	/PROCESS	
						Rework			Skid-tube Crosstube			Water Jet	Engineering
Part N	۱o.					Scrap	:		Machining Small Fab	_	Pro	d. Eng. Coor.	Quality
	•			······································		Use-as-is		Therr	noforming Finishing	3	Rec/Sto	e/Packaging	Other
NCR N	No.					Suspected Unapproved			Large Fab Composite	<u> </u>		Supplier	
Root					Desci	ription of work order update	ı	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data		;					ļ						
Equip/Tooling													
Handling/Pre													
Material		] :											
Operator					i								
Offset/Setup				1			1						
Process	Ш												
Supplier	Ш						Ì						,
Training							ļ						
Transport	$\vdash$												1
Unapproved				<u> </u>	<u> </u>				TECODY			<u> </u>	
						<del></del>	FA	ULI CA	TEGORY				
Landi	ng c	7				General Bend		ارمانه ا	Program		Outside Dim	ansions [	Pressure/Forced
	$\vdash$	Bending	at Canaar	.+-:-	-	BOM/Route	$\vdash$	Grain	riogialli	$\vdash$	Over/Under	<u> </u>	Set-up
	⊢	Centre No Cracks	ot Concer	HITIC	$\vdash$	Broken/Damage/Defect	$\vdash$	Hardw	aro	$\vdash$	Part Incorre	<u> </u>	Temperature/Cure
		Crimp/Kir	nk/Pinnla	Mayo	-	Burrs	$\vdash$	-	tion Incomplete/Unqualified	$\vdash$	Part Lost/M		Weld
	<del> </del>	Cuffs	in with hie	y wave		Contamination	$\vdash$	<b>1</b> '	tions Incomplete/Unclear	$\vdash$	Part Moved	-	Wrong Stock Pulled
	<del> </del>	Crushing				Countersink	$\vdash$	4	gned/off center		Positioned V	ـــ Vrong	
	一	Heat Trea			$\vdash$	Cut Too Short		Mislab	=		Power Loss/	_	Other
		Inspectio		Tube		Drawing	$\vdash$	Misrea			<b>_</b>	J	<u> </u>
į		Marks/Ch	-		_	Drill Holes		Off-set				· ·	
		Turning S				Finish	$\vdash$	4	Calibration		-		
		Wave/Tw				Fit/Function	$\vdash$	-	Sequence				

## Picklist Print

January-15-14 1:11:00 PM

Work Order ID:

111463

Parent Item:

D3488-041

Parent Item Name:

Blade Fitting LH

Comments:

IPP Rev:A New Issue 06-02-28 JLM

IPP Rev:B As per Rev B 06-03-30 JLM

IPP Rev:C Now On Doosan Lathe JLM Verified BY:DD

Start	Date:	1/15	/1 /
Start	Date.	1/1/2/	1 -

14 **R**e

Required Date: 1/31/14

**Start Qty:** 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measur		Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-225 X Insert ALS4	1037-225	Purchased	No				Each	80.0000 128179	(X 110	\ 40://	ربار	53/2	ζ
				Location FG	18520	<b>Loc Oty</b> 80		Loc Code					
D6103-003 Round Billet, Aluminum		Manufactured	No	1	10320	80	Each	26.0000		10	R	14-	2-3
				Location		Loc Qty	;	Loc Code					
				MAT043		20							
					.0129	20				<u></u>			
				MAT047		6							
				95	5020	4							
				96	5416	2							

DQA:			Date:										TRACT
						WORK ORDER NON-	-CC	NFO				–	AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	ır.				i	DISPOSITION			AGAINST	DE	PARTMENT	PROCESS	
WOIK OIG	-''-		-			Rework			Skid-tube Crosstube		Ì	Water Jet	Engineering
Part N	lo.				ļ	Scrap	·		Machining Small Fab	_	Pro	d. Eng. Coor.	Quality
	•					Use-as-is		Thern	noforming Finishing		Rec/Stor	e/Packaging	Other
NCR N	10.					Suspected Unapproved		,	Large Fab Composite	<u> </u>		Supplier	] [ [
Root	_				Desc	ription of work order update		nitial	Action		Sign &		· .
Cause		Date	Step	Qty	,	or non-conformance	I.	ief Eng	<b>}</b>		Date	Verification	QC Inspector
Design					-								
Doc/Data												į	
Equip/Tooling		:			•				·				
Handling/Pre		:							,			į	
Material													
Operator							ļ						
Offset/Setup				,									
Process													
Supplier													
Training					<u> </u>							:	
Transport								•					
Unapproved					<u> </u>								<u></u>
							FAI	ULT CA	TEGORY				
Landi	ng (	1	-		_	General		1			1		¬_
	<u> </u>	Bending			$\perp$	Bend	<u> </u>	1	Program	<u> </u>	Outside Dim	<u>-</u>	Pressure/Forced
		Centre No	ot Concer	ntric	 	BOM/Route	-	Grain		_	Over/Under	-	Set-up
1	<u> </u>	Cracks			<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa		$\vdash$	Part Incorre	<b>⊢</b>	Temperature/Cure Weld
		Crimp/Kii	nk/Ripple	:/Wave	-	Burrs	-	4	tion Incomplete/Unqualified	-	Part Lost/M	Issing	Wrong Stock Pulled
	_	Cuffs			$\vdash$	Countains	$\vdash$	4	tions Incomplete/Unclear	$\vdash$	Part Moved Positioned V	L Vrong	
	$\vdash$	Crushing			-	Countersink Cut Too Short	$\vdash$	Mislab	gned/off center	-	Power Loss/		Other
	-	Heat Trea		Tubo	$\vdash$	Drawing	$\vdash$	Misrea			Ti owei ross/	Juige [	Journey
Inspection Strip in Tube Marks/Chatter		Drill Holes	$\vdash$	Off-set									
	-	Turning S			-	Finish	-	-	Calibration				
	-	4			-	Fit/Function	$\vdash$	-	Sequence				
Wave/Twist in Tube			1. 19 1 411001011		10000				· · · · · · · · · · · · · · · · · · ·				

DART AEROSPACE LTD	Work Order:	111463
<b>Description:</b> Blade Fitting, LH / Turning Detail for D3488-1/-2	Part Number:	D3488-1
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 1 of 2

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

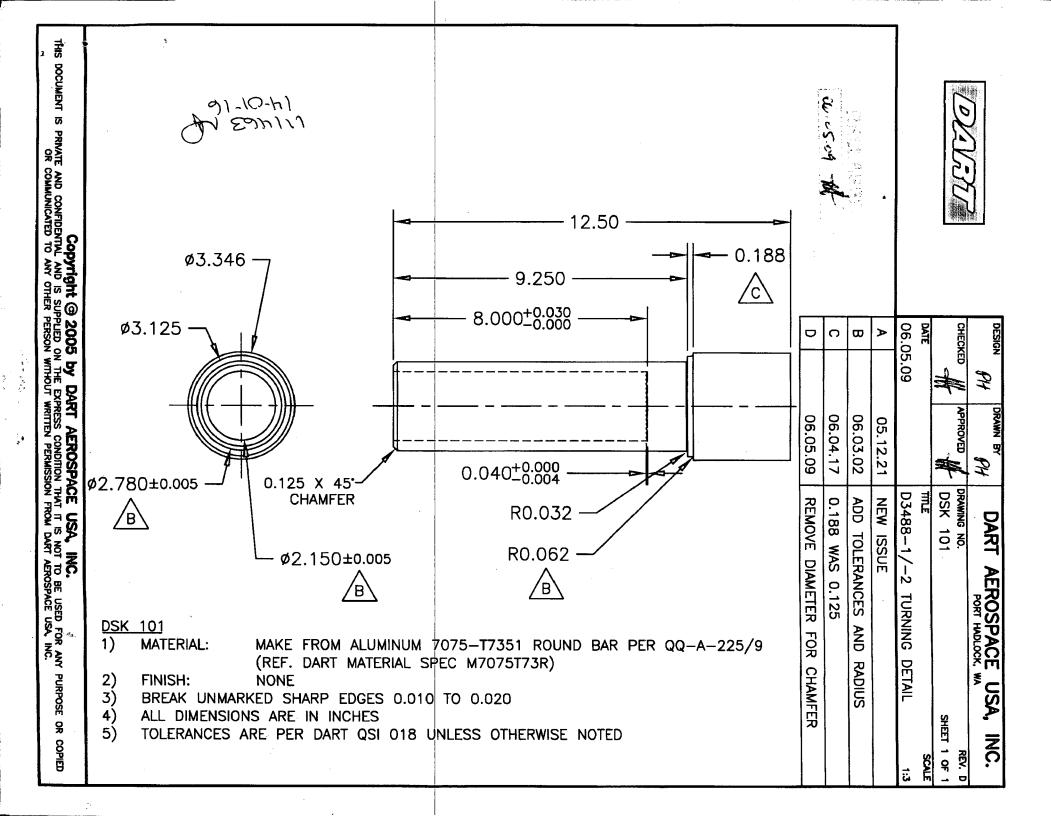
Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments	
Dimension	Tolerance	Dimension	Ассері	Reject	Inspection		
Lathe Section							
Ø2.150	Ø2.150 +/-0.005				VERU	CNY-02	
Ø2.780	+/-0.005	2.780			į (	.,	
Ø3.125	+/-0.010	3,125			ι.	,	
Ø3.346	+/-0.010	3.342				. •	
0.125 x 45°	+/-0.010 x +/-0.1°	.125			/	,,	
8.000	+0.030/-0.000	8.015				•	
9.250		9.250	_/_				
0.188	+/-0.010	.187	V	·	`		
R0.032	+/-0.010	- 032			RAD 6		
R0.062	+/-0.010	. 062			· it		
Ø0.297	+0.005/-0.001	. 299	V		PING	,	
Ø0.430	+/-0.010	.433	/		11		
0.100	+/-0.010	-100			VEW	PMO-12	
0.125	+/-0.010	- 126			10	41	
2.620	+/-0.010	2.615			16	V4	
3.500	+/-0.010	3,345			d	ť	
1.005	+/-0.010	1,005			u	7/	
Ø0.484	+0.005/-0.001	.486	/		PinG		
1.180	+/-0.010	1,180			YEW	P10-12	
3.150	+/-0.010	3,148				l.	
3.070	+/-0.010	3,071			· · ·	, l	
R0.063	+/-0.010	. 063			Rad G		
<u>.                                      </u>							

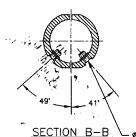
DART AEROSPACE LTD	Work Order:	111463
Description: Blade Fitting, LH / Turning Detail for D3488-1/-2	Part Number:	D3488-1
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 2 of 2

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments		
Milling Section								
Ø0.508	+0.006/-0.001	- 508	1		Pir svase			
0.750	+/-0.010	. 750	1		Caliper	M4-04		
1.500	+/-0.010	1:499			1	1		
11.18	+/-0.030	11.1800	1		D.s. Leist	31006		
R0.062	+/-0.010	-067	1		rad suase			
0.125	+/-0.010	-116	1		Caliper	M4-04		
0.590	+/-0.010	.590	<b>√</b>		Dis. heishT.	31006		
0.793	+/-0.010	. 793	✓		Caliper	MH-04		
1.351	+/-0.010	1.350	-					
1.317	+/-0.010	13175	✓					
1.802	+/-0.010	1.801	<b>✓</b>			T		
	DAST							

Measured by: 40 Mu	Audited by: JHC	Prototype Approval:	N/A
Date: 14/02/27 (4/03/12	Date: 20/4-03-/8	Date:	N/A

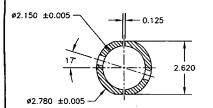
Rev	Date	Change	Rev	vised by	Approved
Α	06.03.31	New Issue	KJ/s	JLM	
В	08.09.19	Reformat P/O	D3488-041 KJ/	JLM LA	
С	08.12.02	Dimension 8.000 removed	KJ/.	JLM K	\u03b4





Ø0.297 C'BORE Ø0.430 x 0.100 INSTALL ALS4-1032-225 (OR AKS4-1032-225 OR ALS7-1032-225 OR AKS7-1032-225) INSERTS AFTER FINISH

(4 PLACES)



SECTION A-A

## 03488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

QTY -041	-042	PART NUMBER	DESCRIPTION
X		D3488-041	BLADE FITTING ASSEMBLY (LH)
	X	D3488-042	BLADE FITTING ASSEMBLY (RH)
1.	+.	D3488-1	BLADE FITTING (LH)
	1	D3488-2	BLADE FITTING (RH)
4	4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

## D3488-041/-042 BLADE FITTING

MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR

PER QQ-A-225/9

(REF. DART MATERIAL SPEC M7075T73R)
ACID ETCH, ALODINE PER DART QSI 005 4.1 2) FINISH:

POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3

BREAK UNMARKED SHARP EDGES 0.010 TO 0.020

INSTALL INSERTS AFTER POWDER COAT

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

